

February-19-14 8:40:29 AM

Page 1

Run	Start	*NR1*
	Stop	*NR2*

<b>Draw Nbr</b>	<b>Revision Nbr</b>
D3646	Rev C

1-Punch to length as per Dwg D3646 & template DT8958

6x

**DAS**  
**28**  
**9-89**

SEP 08 2014

1-Deburr

6x

**DAS**  
**28**  
**9-89**

SEP 08 2014

0.00

## Quality Control

6

**DAS**  
**38**  
**9-89**

14-5-9.

Work Order ID 113495

February-19-14 8:40:29 AM

\*113495\*

Page 2

Item ID: D3646-1

Accept

\*N900040100\*

Setup Start \*NS1\*

Revision ID:

Stop \*NS2\*

Item Name: Arm

Start Date: 2/19/14

Start Qty: 6.00

\*6\*

Cust Item ID:

Required Date: 3/05/14

Req'd Qty: 6.00

\*6\*

Customer:

Reference:

Approvals:

Process Plan: \_\_\_\_\_

Date: \_\_\_\_\_

Tooling: \_\_\_\_\_

Date: \_\_\_\_\_

Run Start \*NR1\*

QC: \_\_\_\_\_

Date: \_\_\_\_\_

SPC (Y/N): \_\_\_\_\_

Date: \_\_\_\_\_

Stop \*NR2\*

Sequence ID/  
Work Center IDOperation  
DescriptionSet Up/  
Run Hours

Tool ID

Tool #

Plan  
CodeAccept  
QtyReject  
QtyReject  
NumberInsp.  
Stamp

130

Black Sandtex (Ref: 4.3.5-7) per OSI005 4.3

0.00

\*130\*

Powdercoat

Memo

0.00

Powder Coating

START TIME: 10.00

OVEN TEMPERATURE: 325°

FINISH TIME: 10.30

6 0 149-10 25 34 00

140

QC3- Inspect Part Finish

0.00

\*140\*

QC

Memo

0.00

Quality Control

6 0 149-10 14/09/10

150

Identify as per dwg &amp; Stock Location: 51459 0.00

\*150\*

Packaging

Memo

0.00

Packaging

6 0 149-11

**Work Order ID 113495**

February-19-14 8:40:29 AM

**\*113495\***

Page 3

Item ID: D3646-1

Accept

**\*N900040100\***Setup Start **\*NS1\***

Revision ID:

Stop **\*NS2\***

Item Name: Arm

Start Date: 2/19/14 Start Qty: 6.00

**\*6\***

Cust Item ID:

Required Date: 3/05/14 Req'd Qty: 6.00

**\*6\***

Customer:

Reference:

Approvals: Process Plan: \_\_\_\_\_ Date: \_\_\_\_\_ Tooling: \_\_\_\_\_ Date: \_\_\_\_\_

Run Start **\*NR1\***

QC: \_\_\_\_\_ Date: \_\_\_\_\_ SPC (Y/N): \_\_\_\_\_ Date: \_\_\_\_\_

Stop **\*NR2\***Sequence ID/  
Work Center IDOperation  
DescriptionSet Up/  
Run HoursTool ID Tool # Plan  
CodeAccept  
QtyReject  
QtyReject  
NumberInsp.  
Stamp

160

QC21- Final Inspection - Work Order Release

0.00

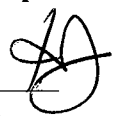
**\*160\***

QC

Memo

0.00

Quality Control

14/9/12   
MFE  
14-2-11

# Picklist Print

February-19-14 8:40:33 AM

Page 1

Work Order ID: 113495

\*113495\*

Parent Item: D3646-1

\*D3646-1\*

Parent Item Name: Arm

Start Date: 2/19/14

Required Date: 3/05/14

Start Qty: 6.00

Required Qty: 6.00

Comments: IPP Rev. A new issue 07.07.25 EC verified by:JLM

Component Item ID/ Item Name	Replacement Item ID	Mfg/ Purch	Bin Item	Primary Location	Last Location	Route Seq ID	Unit of Measure	Qty on Hand	Qty per Kit	Total Qty	Qty Issued	Date Issued	Status
M304TR0.500W.035		Purchased			No	100	f	219.1999	1.98	13			
												DAS 28 9-89	SEP 08 2014
<b>*M304TR0 500W 035*</b>													
304 RD Tube .500 x .035W													

Location

Loc Qty

Loc Code

MAT017

219.1999

125513

16.1999

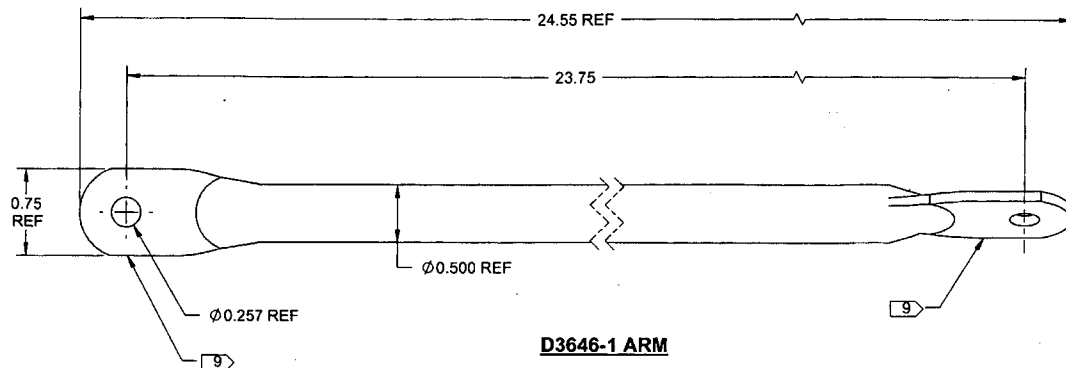
m126922

3

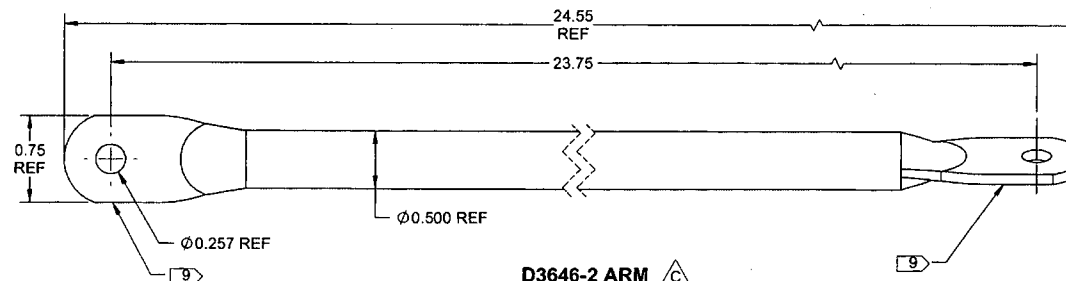
m128084

200

129/88



**D3646-1 ARM**



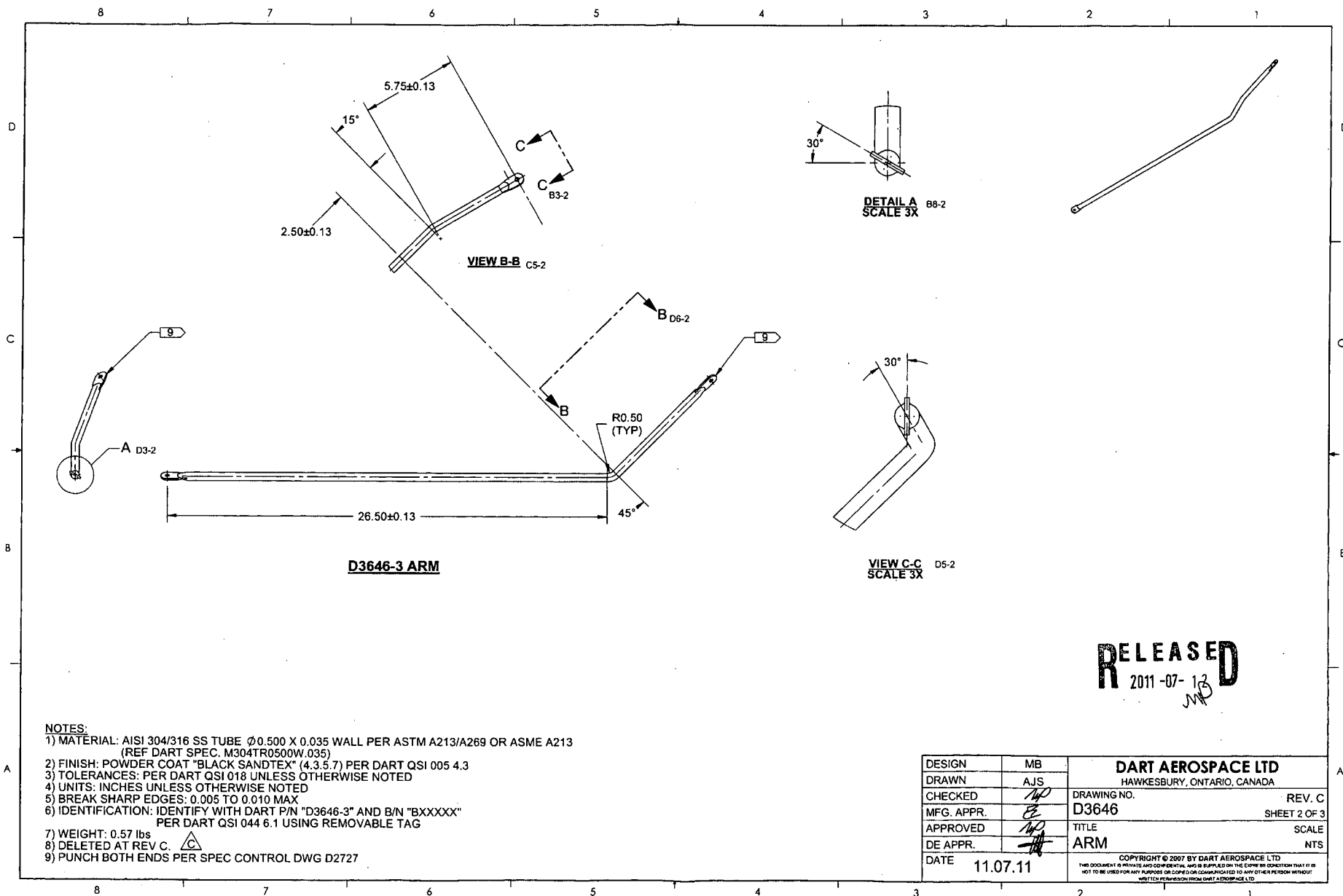
**D3646-2 ARM**

**NOTES:**

- 1) MATERIAL: AISI 304/316 SS TUBE  $\phi 0.500 \times 0.035$  WALL PER ASTM A213/A269 OR ASME A213 (REF DART SPEC. M304TR0500W.035)
- 2) FINISH: POWDER COAT "BLACK SANDTEX" (4.3.5.7) PER DART QSI 005 4.3
- 3) TOLERANCES: PER DART QSI 018 UNLESS OTHERWISE NOTED
- 4) UNITS: INCHES UNLESS OTHERWISE NOTED
- 5) BREAK SHARP EDGES: 0.005 TO 0.010 MAX
- 6) IDENTIFICATION: IDENTIFY WITH DART P/N "D3646-X" AND B/N "BXXXXX" PER DART QSI 044 6.1 USING REMOVABLE TAG
- 7) WEIGHT: 0.38 lbs
- 8) DELETED AT REV. C
- 9) PUNCH BOTH ENDS PER SPEC CONTROL DWG D2727

C	ADD-2 & -4 FOR LHS INSTALLATION. DELETE REFERENCES TO TEMPLATES (NOTE 8) PER SHOP REQUEST.	AJS	11.07.11
B	REFORMAT DWG, ANGLE 65° WAS 45° (ZN C3-1), ADD IDENTIFICATION TAG (ZN A8-1, A8-2)	CP	09.06.04
A	NEW ISSUE	MB	07.06.06
REV.	DESCRIPTION	BY	DATE
DESIGN	MB	<b>DART AEROSPACE LTD</b> HAWKESBURY, ONTARIO, CANADA	
DRAWN	AJS		
CHECKED	MP	DRAWING NO.	REV. C
MFG. APPR.	BE	D3646	SHEET 1 OF 3
APPROVED	MP	TITLE	SCALE
DE APPR.	MP	ARM	NTS
DATE	11.07.11	<small>COPYRIGHT © 2007 BY DART AEROSPACE LTD THIS DOCUMENT IS PRIVATE AND CONFIDENTIAL, AND IS SUPPLIED ON THE EXPRESS CONDITION THAT IT IS NOT TO BE USED FOR ANY PURPOSE OR COPIED OR COMMUNICATED TO ANY OTHER PERSON WITHOUT WRITTEN PERMISSION FROM DART AEROSPACE LTD.</small>	

NO. 113495-ML5  
14-02-19



# NOTES:

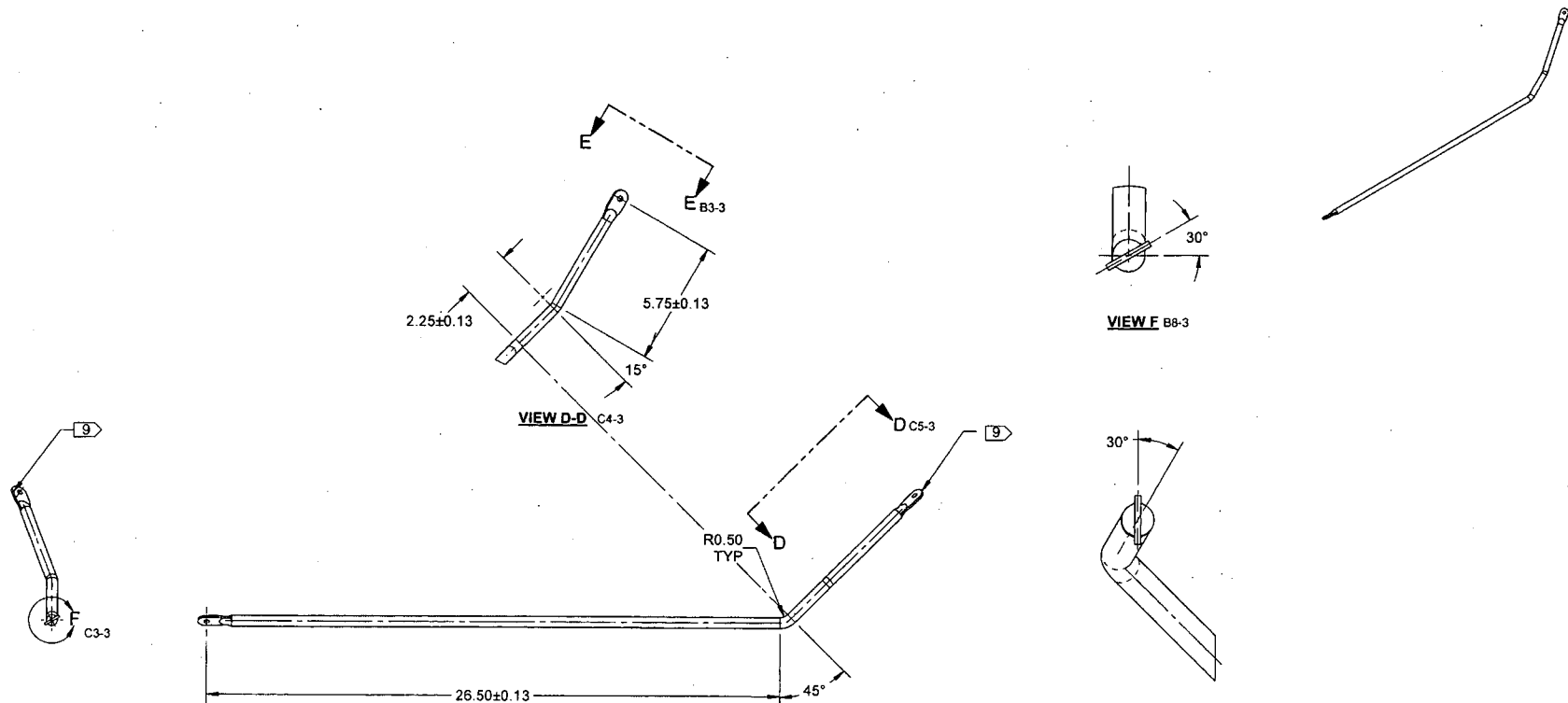
- 1) MATERIAL: AISI 304/316 SS TUBE  $\varnothing 0.500 \times 0.035$  WALL PER ASTM A213/A269 OR ASME A213 (REF DART SPEC. M304TR0500W.035)
- 2) FINISH: POWDER COAT "BLACK SANDTEX" (4.3.5.7) PER DART QSI 005 4.3
- 3) TOLERANCES: PER DART QSI 018 UNLESS OTHERWISE NOTED
- 4) UNITS: INCHES UNLESS OTHERWISE NOTED
- 5) BREAK SHARP EDGES: 0.005 TO 0.010 MAX
- 6) IDENTIFICATION: IDENTIFY WITH DART P/N "D3646-3" AND B/N "BXXXXX" PER DART QSI 044 6.1 USING REMOVABLE TAG
- 7) WEIGHT: 0.57 lbs
- 8) DELETED AT REV C.
- 9) PUNCH BOTH ENDS PER SPEC CONTROL DWG D2727

DESIGN	MB	<b>DART AEROSPACE LTD</b>	
DRAWN	AJS	HAWKESBURY, ONTARIO, CANADA	
CHECKED	<i>[Signature]</i>	DRAWING NO.	REV. C
MFG. APPR.	<i>[Signature]</i>	<b>D3646</b>	SHEET 2 OF 3
APPROVED	<i>[Signature]</i>	TITLE	SCALE
DE APPR.	<i>[Signature]</i>	<b>ARM</b>	NTS
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8 7 6 5 4 3 2 1

D  
C  
B  
A

D  
C  
B  
A



**D3646-4 ARM**

**RELEASED**  
2011-07-12  
JWP

- NOTES:**
- 1) MATERIAL: AISI 304/316 SS TUBE  $\phi 0.500 \times 0.035$  WALL PER ASTM A213/A269 OR ASME A213 (REF DART SPEC. M304TR0500W.035)
  - 2) FINISH: POWDER COAT "BLACK SANDTEX" (4.3.5.7) PER DART QSI 005 4.3
  - 3) TOLERANCES: PER DART QSI 018 UNLESS OTHERWISE NOTED
  - 4) UNITS: INCHES UNLESS OTHERWISE NOTED
  - 5) BREAK SHARP EDGES: 0.005 TO 0.010 MAX
  - 6) IDENTIFICATION: IDENTIFY WITH DART P/N "D3646-4" AND B/N "BXXXXX" PER DART QSI 044 6.1 USING REMOVABLE TAG
  - 7) WEIGHT: 0.57 lbs
  - 8) DELETED AT REV C.
  - 9) PUNCH BOTH ENDS PER SPEC CONTROL DWG D2727

DESIGN	MB	<b>DART AEROSPACE LTD</b> HAWKESBURY, ONTARIO, CANADA	
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CHECKED		DRAWING NO.	REV. C
MFG. APPR.		D3646	SHEET 3 OF 3
APPROVED		TITLE	SCALE
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8 7 6 5 4 3 2 1